

# Work Order ID 86076

June-20-12 12:55:08 PM

**\*86076\***

Page 1

Item ID: 41232-200-001-002

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Step Actuator RH Ass'y

Start Date: 20/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/12 Tooling:

Run Start **\*NR1\***

QC: Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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41232-200-001	Rev IR
---------------	--------

100

0.00

**\*100\***

Small Fab

Small Fab

Memo

0.00

Small Fab

1- Assemble as per Dwg 41232-200-001  
2-Torque as per Dwg 41232-200-001

FF 12-08-07

110

QC5- Inspect part completeness to step on W/O

0.00

**\*110\***

QC

Memo

0.00

Quality Control

Smb 12.8.07 DAS 16 12/06/07

120

Identify as per dwg & Stock Location:

0.00

**\*120\***

Packaging

Memo

0.00

Packaging

77786074

IX 80 12-8-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 86076**

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**\*86076\***

Page 2

Item ID: 41232-200-001-002

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Step Actuator RH Ass'y

Stop **\*NS2\***

Start Date: 20/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

130

QC21- Final Inspection - Work Order Release

0.00

**\*130\***

QC

Memo

0.00

Quality Control

12/8/8 90  
MLJ 12/08/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Page 1

Work Order ID: 86076

Parent Item: 41232-200-001-002

Parent Item Name: Step Actuator RH Ass'y

\*86076\*

\*41232-200-001-002\*

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-02-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
41232-200-002-001		Manufactured	No			100	Each	1.0000	1	1			
*41232-200-002-001*										**		FF 12-08-07	
tube													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST364		1							
				80914		1							
41232-200-002-003		Manufactured	No			100	Each	7.0000	1	1			
*41232-200-002-003*										**		FF 12-08-07	
latch													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST364		7							
				43304		7							
41232-200-002-005		Manufactured	No			100	Each	15.0000	1	1			
*41232-200-002-005*										**		FF 12-08-07	
pivot arm													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST364		15							
				43305		7							
				44347		8							
41232-200-003-001		Manufactured	No			100	Each	90.0000	1	1			
*41232-200-003-001*										**			
Spring (Step Actuator)													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST365		90							
				54173		90							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Work Order ID: 86076

Parent Item: 41232-200-001-002

Parent Item Name: Step Actuator RH Ass'y

\*86076\*

\*41232-200-001-002\*

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 1.00

Required Qty: 1.00

41232-200-005-003

Manufactured No

100 Each

9.0000

2 2

\*41232-200-005-003\*

Spacer (Step Actuator)

\*\*

FF 12-08-07

## Location

## Loc Qty

## Loc Code

ST364

9

30501

1

61028

8

2

AN315-4R

Purchased

No

100 Each

23.0000

1

1

\*AN315-4R\*

Nut

\*\*

FF 12-08-07

## Location

## Loc Qty

## Loc Code

ST344

23

17566

23

AN3-22A

Purchased

No

100 Each

29.0000

1

1

\*AN3-22A\*

Bolt

\*\*

FF 12-08-07

## Location

## Loc Qty

## Loc Code

ST352

29

110998

20

111072

9

AN842-4D

Purchased

No

100 Each

5.0000

1

1

\*AN842-4D\*

Elbow

\*\*

FF 12-08-07

## Location

## Loc Qty

## Loc Code

ST328

5

115299

1

120953

4

AN960JD10

NAS1149D0363J

Purchased

No

100 Each

0.0000

2

2

\*AN960JD10\*

Washer

\*\*

122378

2

FF 12-08-07

June-20-12 12:55:12 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 86076

Parent Item: 41232-200-001-002

Parent Item Name: Step Actuator RH Ass'y

\*86076\*

\*41232-200-001-002\*

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN960JD416

NAS1149D0463J

Purchased

No

100

Each

30.0000

2

2

\*AN960JD416\*

Washer

\*\*

FF 12-08-07

Location

Loc Qty

Loc Code

ST351

122441

30

2

116289

10

119097

20

D3975-042

Manufactured

No

100

Each

7.0000

1

1

\*D3975-042\*

Gas Cylinder Assembly, RH

\*\*

FF 12-08-07

Location

Loc Qty

Loc Code

ST079

7

60410

3

61799

4

MS16996-23

Purchased

No

100

Each

398.0000

1

1

\*MS16996-23\*

cap screw

\*\*

FF 12-08-07

Location

Loc Qty

Loc Code

ST333

398

112492

398

MS20822-4

Purchased

No

100

Each

5.0000

1

1

\*MS20822-4\*

elbow

\*\*

FF 12-08-07

Location

Loc Qty

Loc Code

ST299

122141

5

120953

5

June-20-12 12:55:12 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

Work Order ID: 86076

Parent Item: 41232-200-001-002

Parent Item Name: Step Actuator RH Ass'y

\*86076\*

\*41232-200-001-002\*

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

100

Each

1.654.000

1

1

\*MS21042L3\*

Nut

\*\*

FF 12-08-07

Location

Loc Qty

Loc Code

ST300 122141

1654

117885

32

119017

816

119075

138

121444

668

1

S-1455

Purchased

No

100

Each

64.0000

1

1

\*S-1455\*

spring-step actuator (replaces 71459)

\*\*

FF 12-08-07

Location

Loc Qty

Loc Code

ST396

64

110154

36

111342

28

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

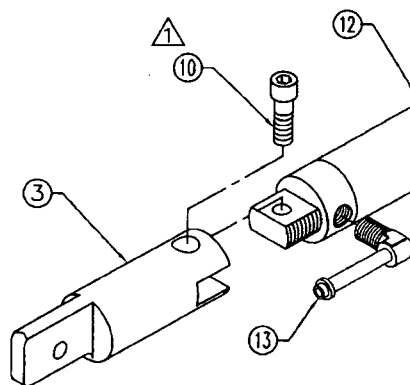
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

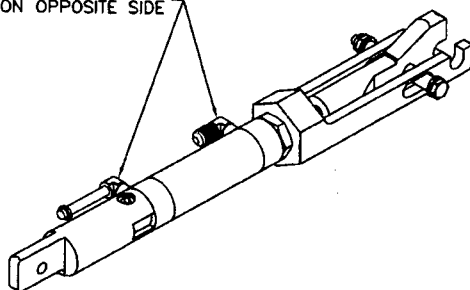
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





-001 L/H ACTUATOR ASSY



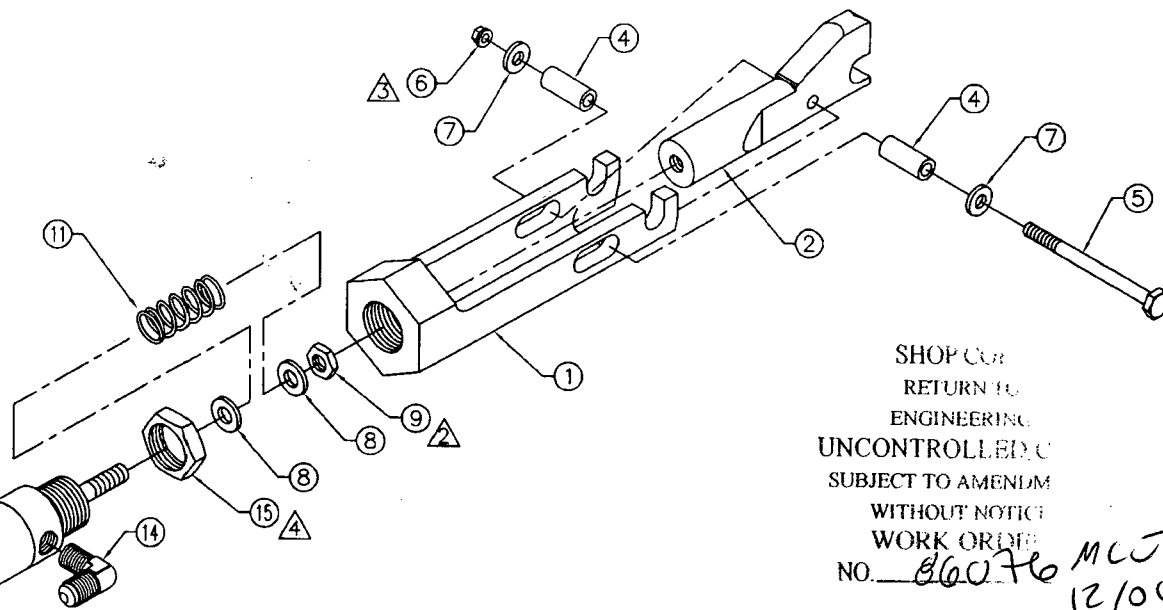
INSTALL ITEM #12  
ON OPPOSITE SIDE



-002 R/H ACTUATOR ASSY

-  TORQUE 80-100 IN.-LB.  
 TORQUE 20-25 IN.-LB.  
 TORQUE 50-75 IN.-LB.  
 TORQUE 50-75 IN.-LB.

NOTES:



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 86076

MCJ  
12/06/20

			1	1	15	3/4x20 BRASS	CYLINDER NUT					
			1	1	14	MS20822-4	ELBOW					
			1	1	13	AN842-4D	ELBOW					
			1	1	12	41232-200-007-001	CYLINDER					
			1	1	11	71459	SPRING					
			1	1	10	MS16996-23	CAP SCREW					
			1	1	9	AN315-4R	NUT					
			2	2	8	AN960JD416	WASHER					
			2	2	7	AN960JD10	WASHER					
			1	1	6	MS21042-L3	NUT					
			1	1	5	AN3-22A	BOLT					
			2	2	4	41232-200-005-003	SPACER					
			1	1	3	41232-200-002-005	PIVOT ARM					
			1	1	2	41232-200-002-003	LATCH					
			1	1	1	41232-200-002-001	TUBE					
			/	/		-002	R/H ACTUATOR ASSY					
			/	/		-001	L/H ACTUATOR ASSY					
			-002	-001	FWD NO.	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE	

PROPRIETARY  
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002	1	41232-000-001
001		

**NEXT ASSEMBLY**

UNLESS  
OTHERWISE  
SPECIFIED  
X.±.1  
XX.±.03  
XXX.±.010  
ANGLES  
±.1/2

DRIFTSMIN
CHECK
STRESS
PROJ.
ENGR.
HEAT TREA
FINISH

D. NI
D. MU

ELSON  
MURPHY

5/20/02
5/20/02

TITLE	S
DWG. SIZE	

STEP

E C

ACTU	
SCALE	
DWG.	
411	

ATOR  
N  
NO.  
232-20

ASS

IONE

0.001

Y	REV.
	ID

**Era Aviation, Inc.**

41232-200-001

REV.  
IR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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